

Date: Thursday, 9/14/2006 7:29:23 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 28564	
Estimate Number : 12165	
P.O. Number : N/A	Part Number : D34753
This Issue : 9/14/2006 S.O. No. :	Drawing Number : D3475 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26279	Material : N/A
Written By : _____	Due Date : 10/6/2006
Checked & Approved By : <u>060914</u>	Qty: 4 Um: Each
Comment : Est Rev:A New Issue 06-02-03 JLM Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.1281 sf(s)/Unit Total : 0.5124 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: M101000

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut as per Dwg D3475

Dwg Rev: BProg Rev: BSAD 06:09:23

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINESAD 06:09:23

(4)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK0609-25 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Roll as per Dwg D3475

2-Bead as per Dwg D3475

SB06/09/23 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: LD Date: 06/09/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28564

Part Number: D34753

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Spot Weld as per Dwg D3475

SB 04/09/22 (4)

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 06/09/27 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GA

SB 04/09/27 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
SB 06/09/27

Job Completion



W 26/09/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

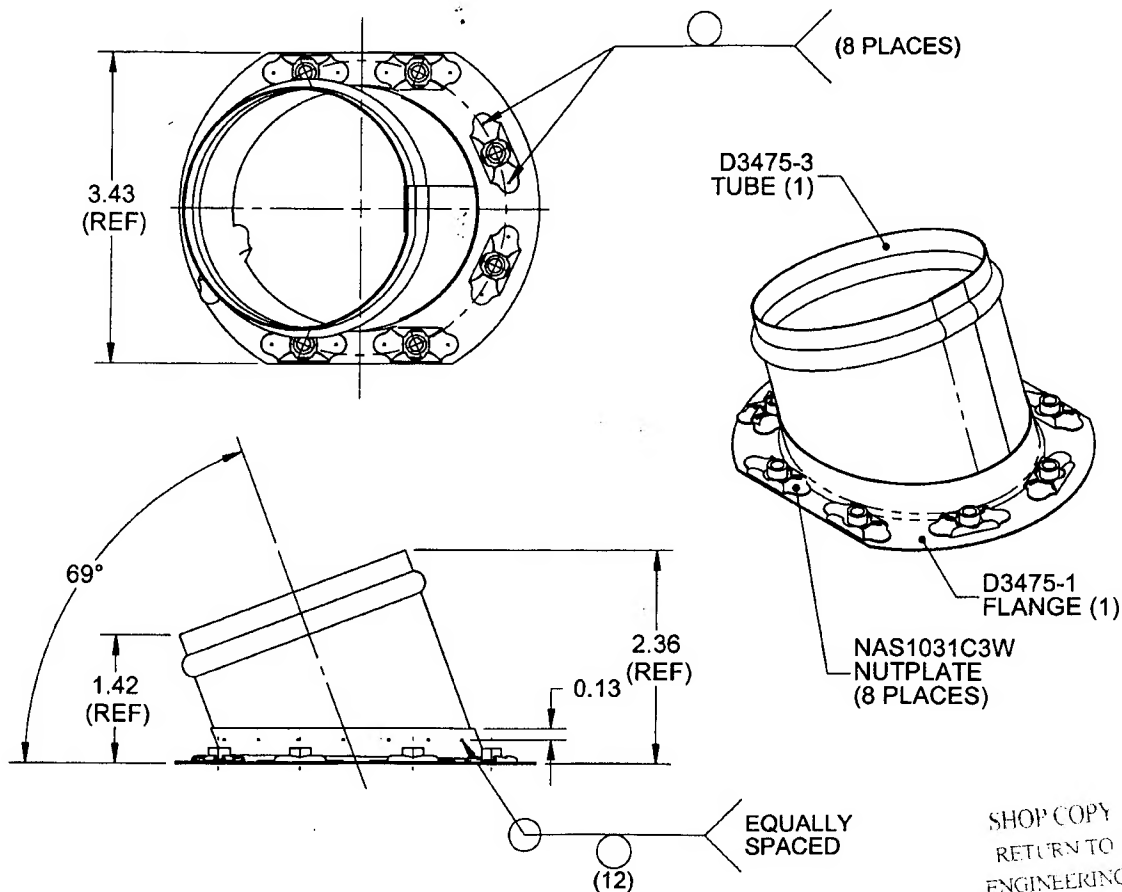
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3475	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:2
A	06.01.24	NEW ISSUE	
B	06.05.16	REDESIGN D3475-1F/-5/-7S/-7; ADD D3475-9	

RELEASED
06-05-16



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NO. 28564

D3475-041 DUMP OUTLET

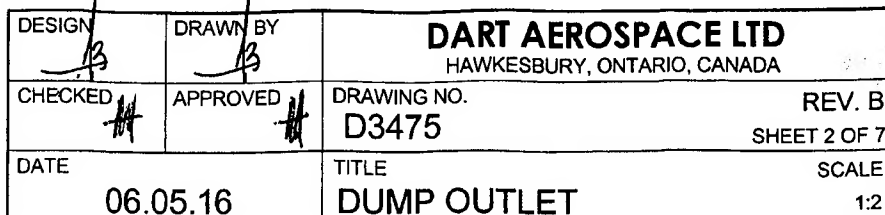
NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

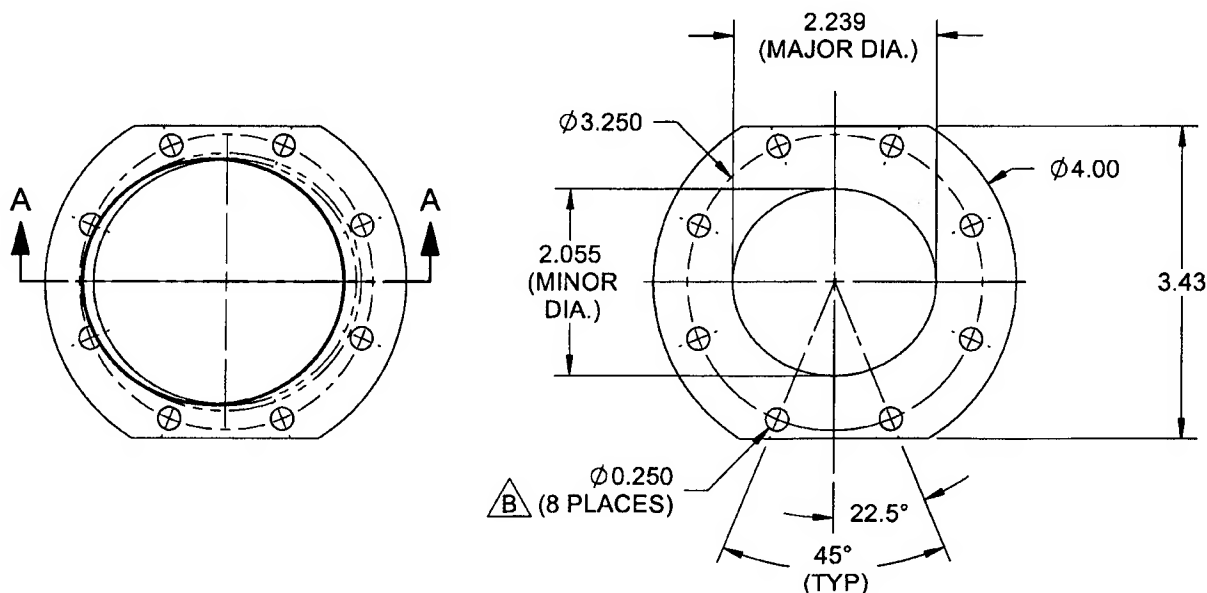
QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

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RELEASE
06-05-16



D3475-1 OUTLET ADAPTER PLATE

D3475-1F FLAT PATTERN

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

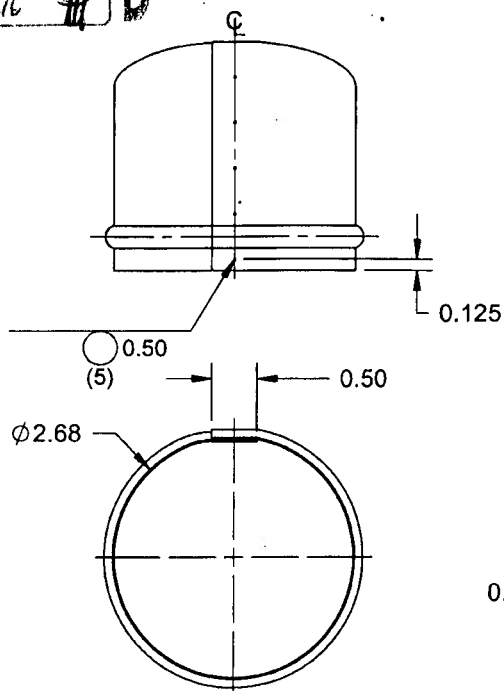
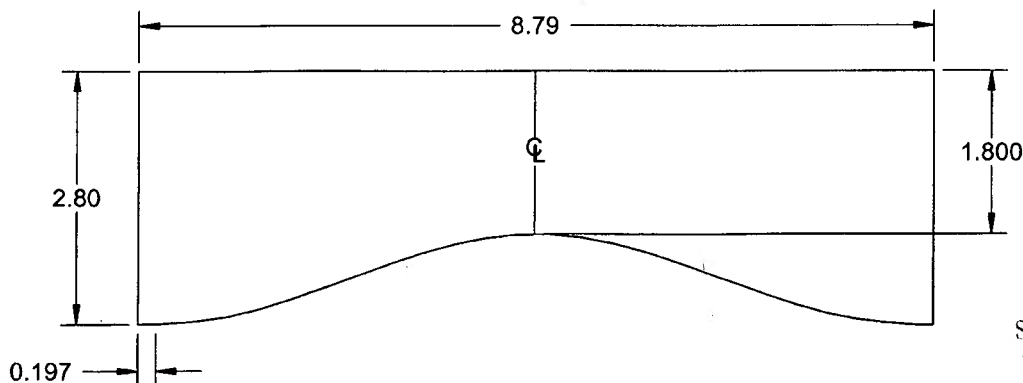
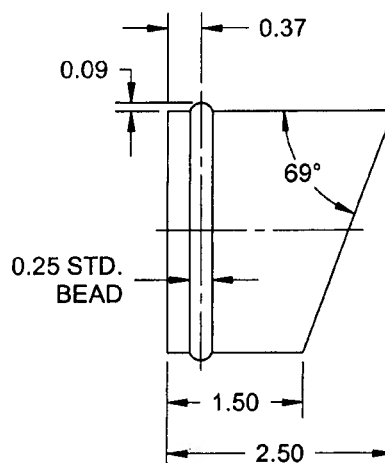
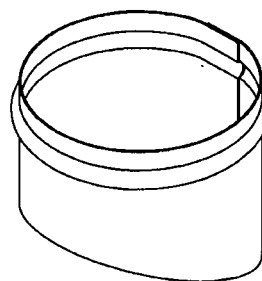
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED #	APPROVED #	DRAWING NO. D3475	REV. B SHEET 3 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:2

RELEASED
06.05.16 #**D3475-3 TUBE****D3475-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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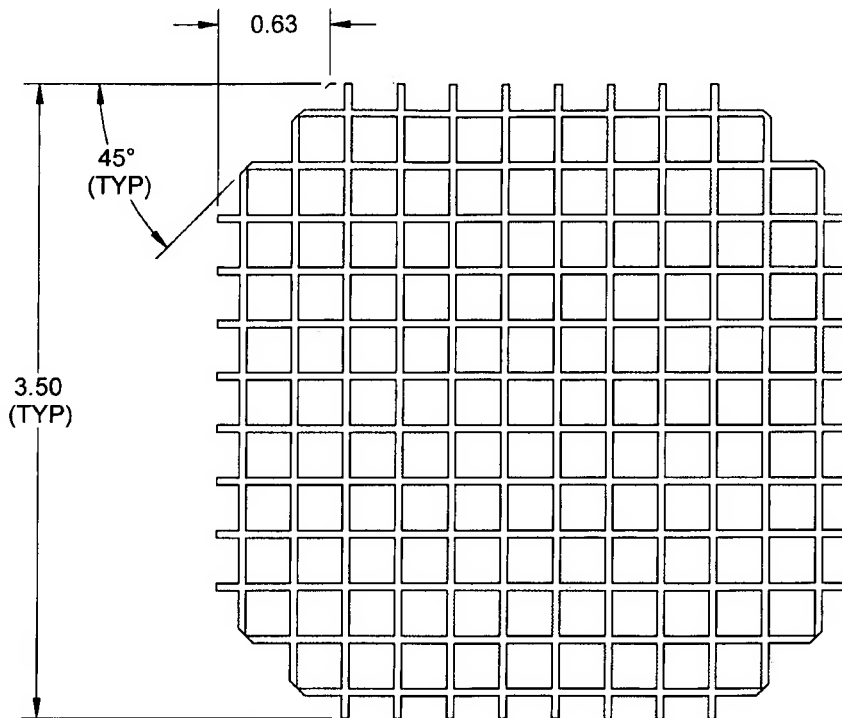
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DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1

RELEASED
06.05.16



D3475-5 SCREEN

NOTES:

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

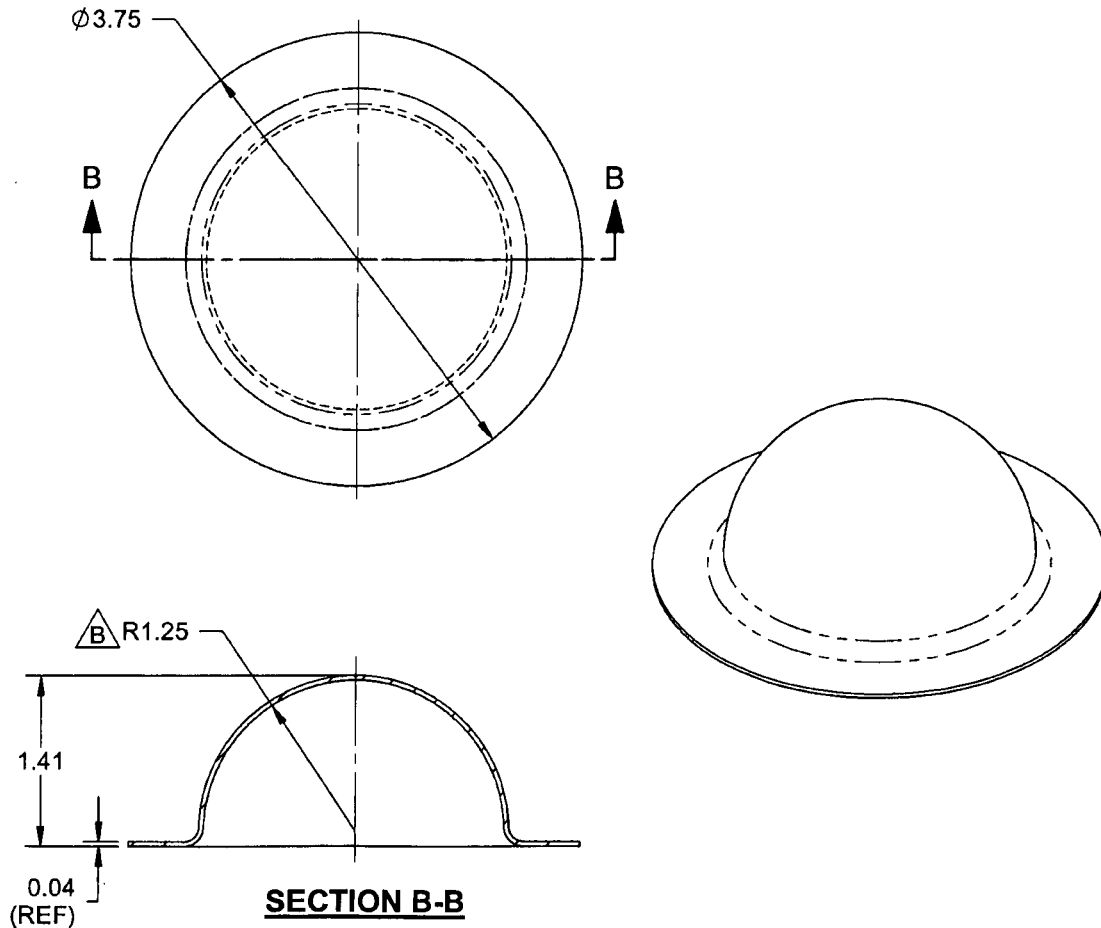
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. B SHEET 5 OF 7
DATE 06.05.16	TITLE DUMP OUTLET		SCALE 1:1.5

RELEASED
06.05.16 *[Signature]***D3475-7S SCOOP OUTLET, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

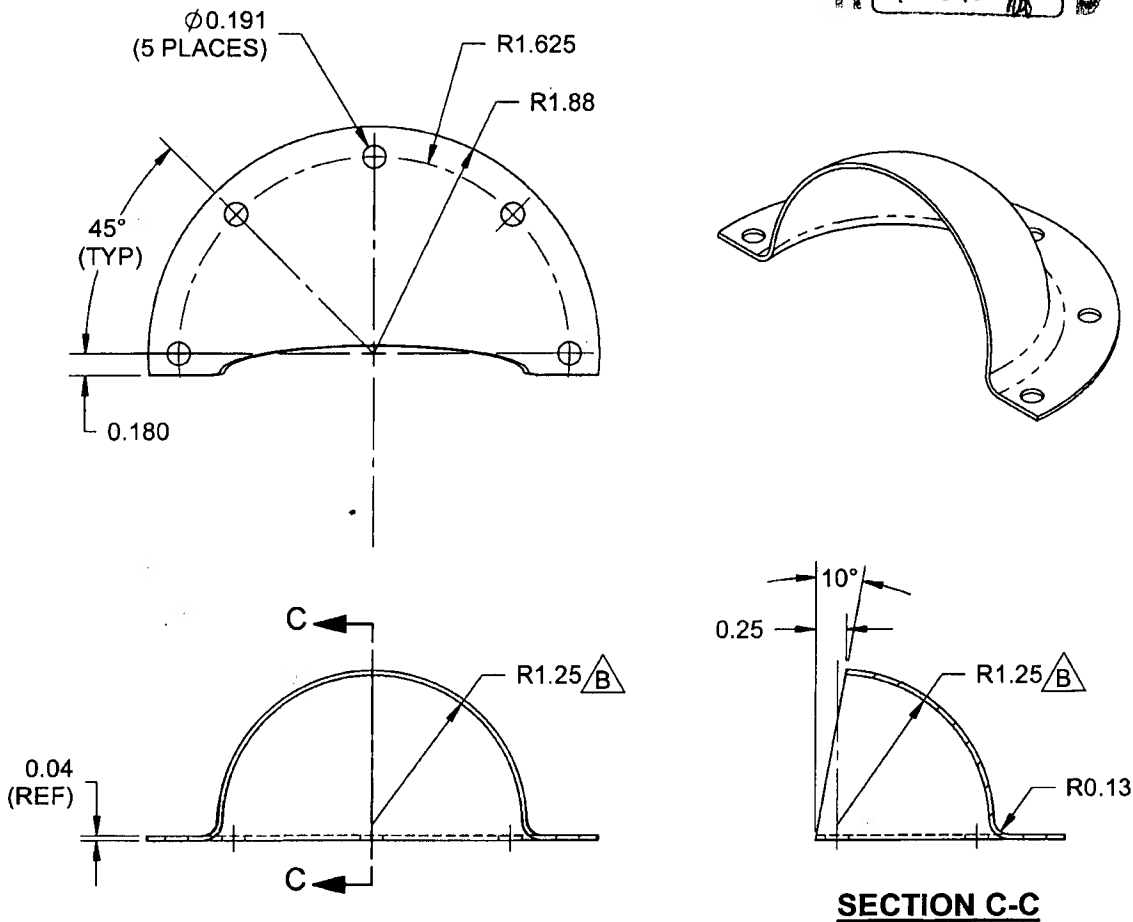
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DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

RELEASED
06.05.16 H**D3475-7 SCOOP OUTLET****NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

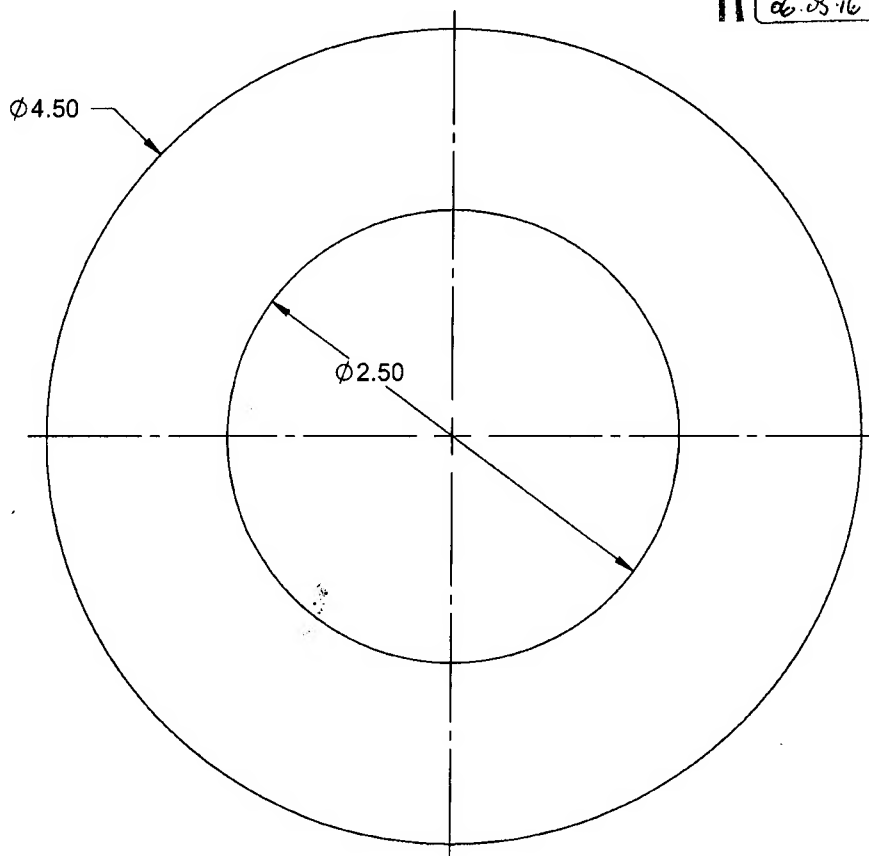
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1

RELEASED
06.05.16**D3475-9 OUTLET GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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